

Work Order ID 76463

76463

Page 1

November-15-11 8:06:08 AM

Item ID: D4109-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Doubler Assembly
 Start Date: 15/11/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 29/11/2011 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/15 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4109 | A |

100 Weld per dwg A/R S.S. rod Batch: M 114509 0.00

100 Q 12-1-18 (12)
 Large Fab Memo 0.00
 Large Fab

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
110 Pl 12-01-19 12x
 QC Memo 0.00
 Quality Control

120 QC5- Inspect part completeness to step on W/O 0.00
120 5 12/01/19 (12)
 QC Memo 0.00
 Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|--------------------------|
| 130 *130* Packaging Packaging | Identify as per dwg & Stock Location: <u>129</u> Memo | 0.00 0.00 | | | | | | | <u>12/1/19</u> <u>12</u> |
| 140 *140* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | <u>12/1/20</u> <u>12</u> |

M.L.J
 12/01/20
 (12)

| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

November-15-11 8:06:15 AM

76463

D4109-043

Required Date: 29/11/2011

Required Qty: 4.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

[illegible]

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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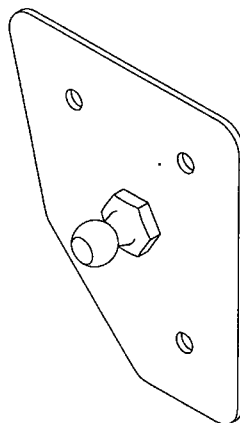
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

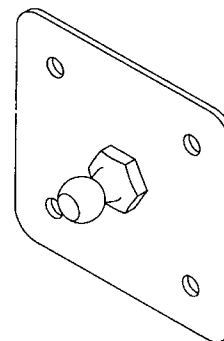
| Qty -041 | Qty -043 | Part Number | Description |
|-------------|-------------|-------------|----------------------------|
| | | D4109-041 | DOUBLER ASSEMBLY, BULKHEAD |
| | | D4109-043 | DOUBLER ASSEMBLY |
| 1 | | D4109-1 | PLATE, BULKHEAD |
| 1 | | D4109-3 | PLATE |
| 1 | | D3622-11 | BALL STUD |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 76463 M.C.J
11/11/15



D4109-041 DOUBLER ASSEMBLY, BULKHEAD



D4109-043 DOUBLER ASSEMBLY

RELEASED
2010-09-23
MR

| | | | | | |
|------------|-------------|---|--|-----|----------|
| A | | NEW ISSUE | | JPH | 10.07.20 |
| REV. | DESCRIPTION | | | BY | DATE |
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4109 TITLE DOUBLER ASSEMBLY SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small> | | | |
| DRAWN | JPH | | | | |
| CHECKED | JPH | | | | |
| MFG. APPR. | JPH | | | | |
| APPROVED | JPH | | | | |
| DE APPR. | JPH | REV. A SHEET 1 OF 3 | | | |
| DATE | 10.07.20 | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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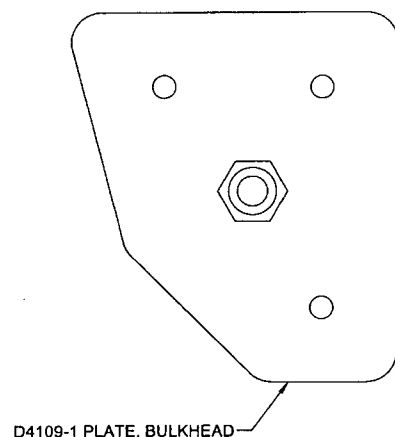
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

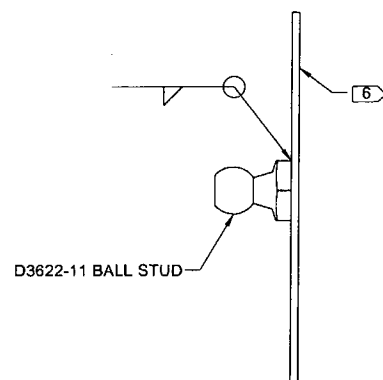
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NOTE: Date & initial all entries

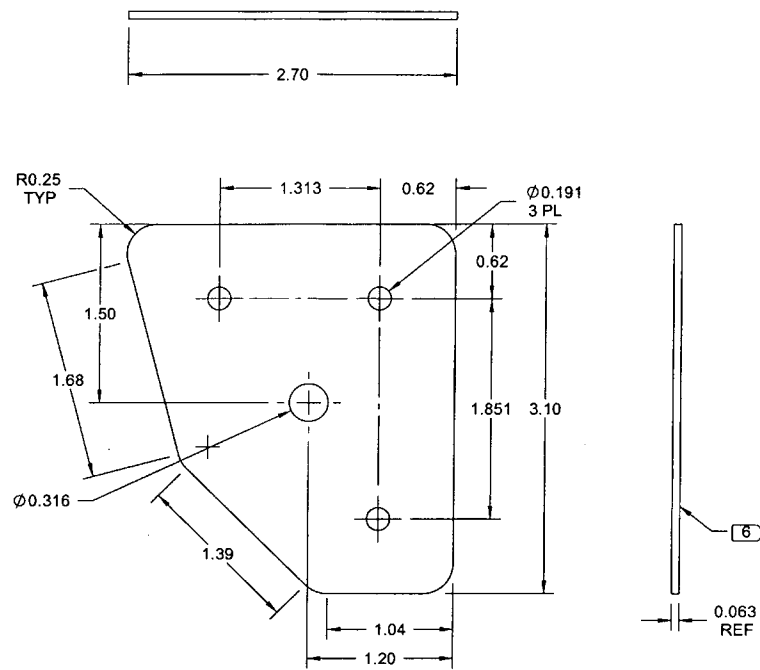
76463



D4109-1 PLATE, BULKHEAD



D3622-11 BALL STUD



D4109-1 PLATE, BULKHEAD

D4109-041 DOUBLER ASSEMBLY, BULKHEAD

RELEASED
2010-09-23

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.063 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4109-X & B/N PER QSI 044 6.1
- 7) WEIGHT -041: 0.14 lbs
- 8) WELD PARTS PER QSI.004.

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| CHECKED | JPH | DRAWING NO. | REV. A |
| MFG. APPR. | JPH | D4109 | SHEET 2 OF 3 |
| APPROVED | JPH | TITLE | SCALE |
| DE APPR. | JPH | DOUBLER ASSEMBLY | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

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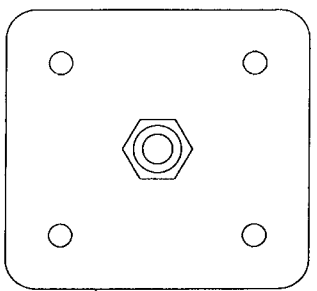
C

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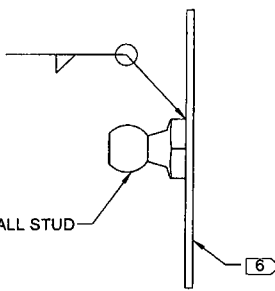
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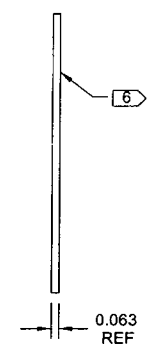
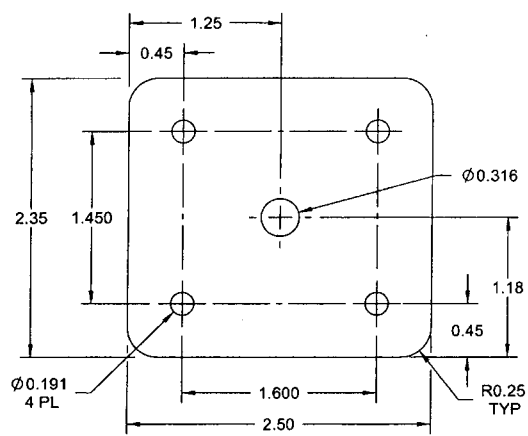
D4109-3 PLATE



D3622-11 BALL STUD



D4109-043 DOUBLER ASSEMBLY



D4109-3 PLATE

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PER DART SPEC M304S16GA OR M303S16GA
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4109-X & B/N PER QSI 044 6.1
- 7) WEIGHT-043: 0.12 lbs
- 8) WELD PARTS PER QSI 004.

RELEASED
2010-09-23

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|------------|----------|--|--------------|
| DESIGN | JPH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | JPH | DRAWING NO. | REV. A |
| MFG. APPR. | | D4109 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | DOUBLER ASSEMBLY | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
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